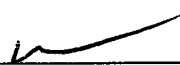


Date: Wednesday, 05/07/2006 2:31:10 PM -  
User: Linda Lacelle









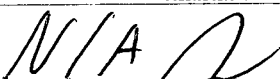
# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER ASSEMBLY, LH
Job Number	: 27836		
Estimate Number	: 10401		
P.O. Number	: <i>NIA</i>	Part Number	: D3163041
This Issue	: 05/07/2006 S.O. No. : <i>NIA</i>	Drawing Number	: D3163 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i> Type : LARGE FAB ASSY	Drawing Revision	: D
Previous Run	: 27349	Material	: <i>NIA</i>
Written By	: 	Due Date	: 12/07/2006
Checked & Approved By	: _____	Qty:	<i>3</i> Um: Each
Comment	: Est. A05.10.25 New issue KJ/RF Est Rev:06-07-03 As per Rev D JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3163041	Cover Assembly
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Plate REMOVE FROM STK" Qty Part Number Batch 1 D3163-041 <i>B25625 (3X)</i> <i>FF 06.07.07</i> <i>3</i>	
2.0	MS20426AD34	RIVET
		
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) RIVET Batch: <del><i>MS20426</i></del> <i>MS 20426AD 4-4 / M 1021</i> <i>FF 06.07.07</i> <i>3</i>	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 <i>Drill /</i> Rivet/COUNTERSINK D3163-041 Touch up c'sink holes with alodine. <i>FF 06.07.07</i> <i>3</i>	
4.0	QC5	INSPECT WORK TO CURRENT STEP
		
	Comment: INSPECT WORK TO CURRENT STEP Inspect bonding of D3163-1/-3 <i>NIA</i> 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3183041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-05	2	Holes drilled to "128" instead of "098"	AB assn	USE MS 2042G AD4-4 instead of MS 2042G AD34 FF	06-10-05	AB 06-10-05	AB 06-10-05	AB 06-10-05

NOTE: Date & initial all entries

Date: Wednesday, 05/07/2006 2:31:10 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER ASSEMBLY, LH

Job Number: 27836

Part Number: D3163041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*N/A & already primed*

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*Rec'd 10/6 (3)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify top assembly on the back side of assembly with Dart P/N and B/N using fine point permanent ink marker and Stock USING NEW B/N

Location: *57129*

*Rec'd 11/6 (3)*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/10/11 (3)*

Job Completion

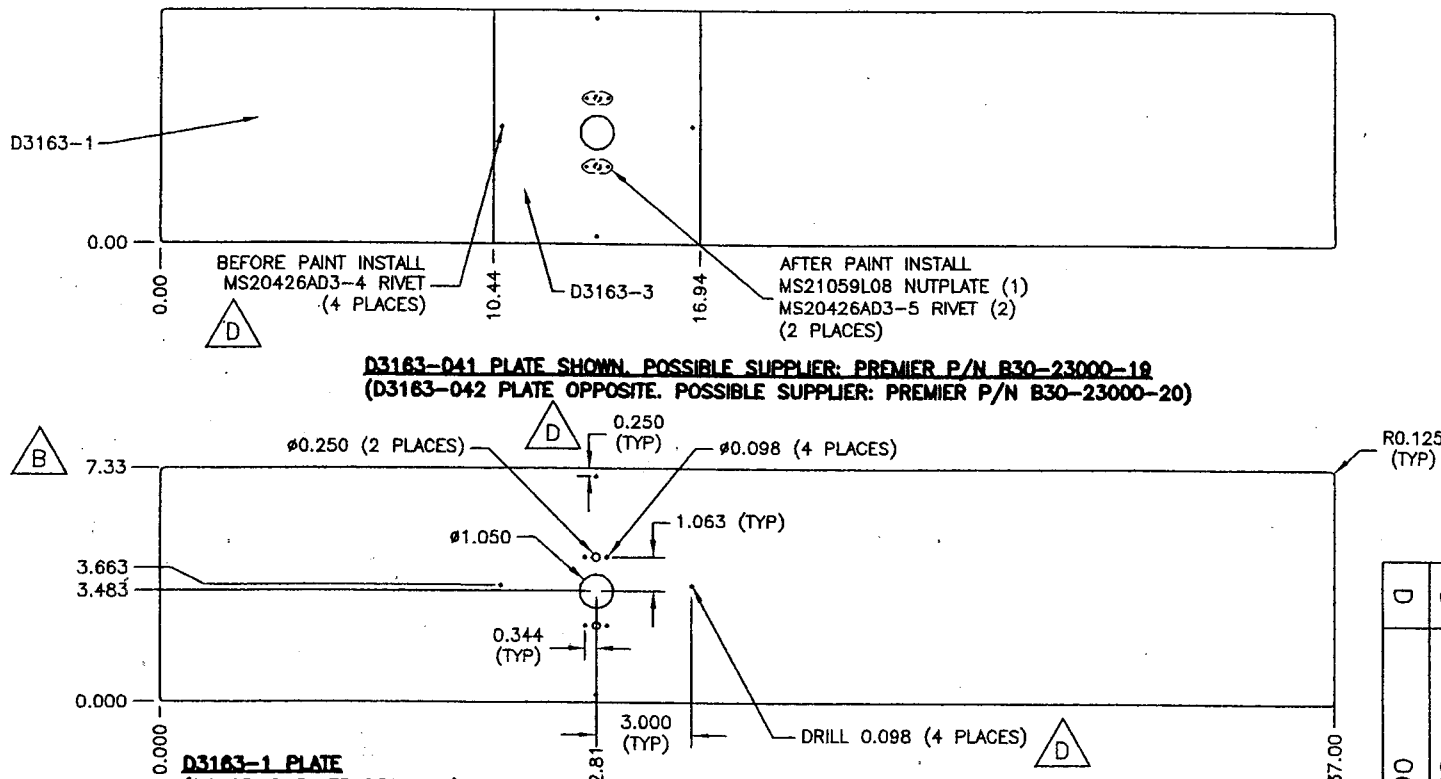


*U 2010.11*



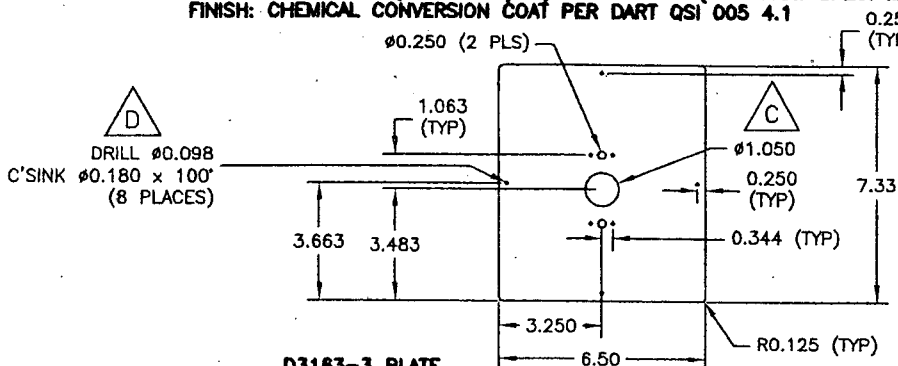
RELEASED  
06-06-26

DESIGN	RF	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO. D3163
DATE	06.06.26	TITLE	PLATE	REV. D
				SHEET 1 OF 1
				SCALE 1:6
A	02.04.26	NEW ISSUE		
B	04.10.06	7.33 WAS 7:20; REMOVE PERIMETER HOLES		
C	05.11.22	Ø1.050 WAS Ø1.000		
D	06.06.26	ADD 4 RIVETS; REMOVE ADHESIVE		



D3163-041 PLATE SHOWN. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19  
(D3163-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)

**D3163-1 PLATE**  
(D3163-2 PLATE OPPOSITE)  
MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR  
6061-T6 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M6061T6S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



**D3163-3 PLATE**  
MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063) OR  
6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

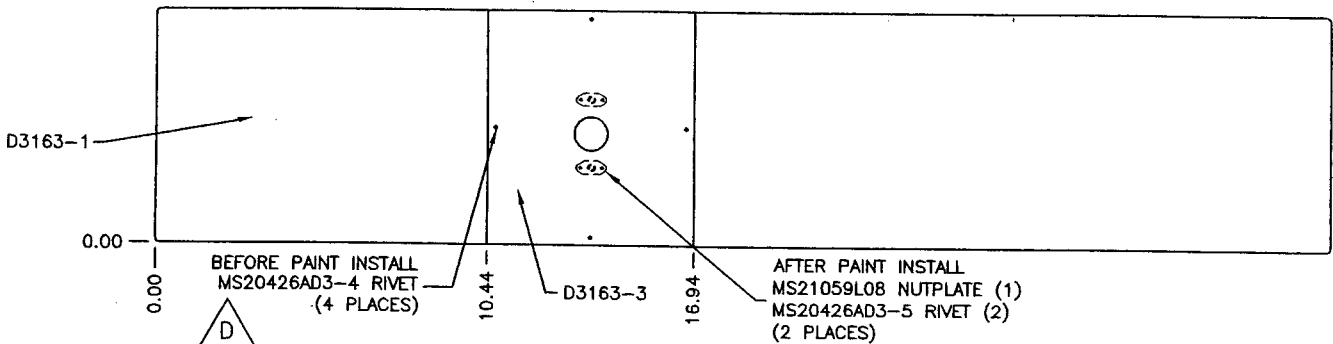
**GENERAL NOTES:**

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

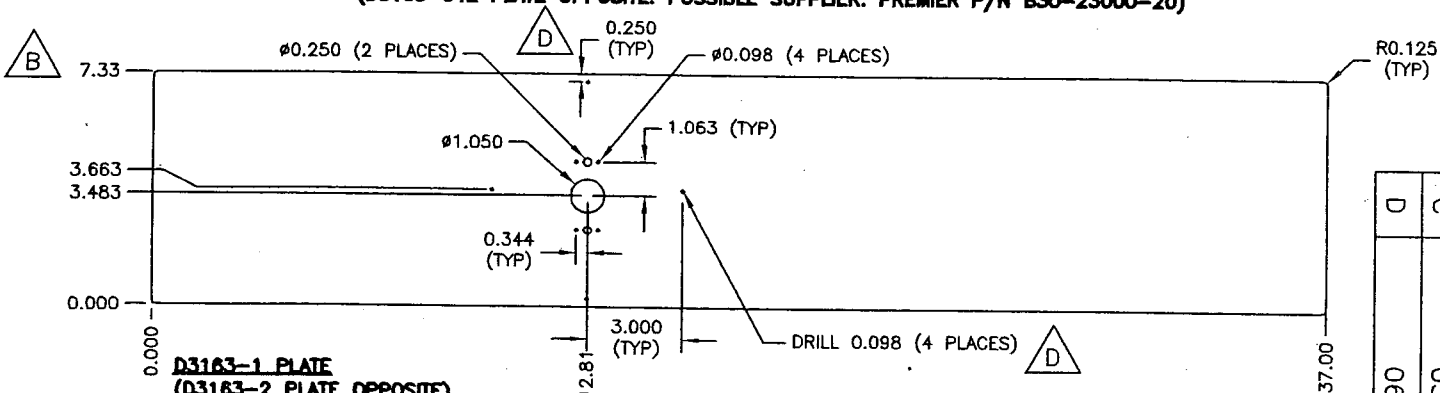
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WORK ORDER  
NO. \_\_\_\_\_

RELEASED  
22-06-29

DESIGN	RF	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. D
CHECKED	PH	APPROVED	PH	DRAWING NO.	D3163	SHEET 1 OF 1
DATE	06.06.26		TITLE		SCALE	
			PLATE		1:6	
A	02.04.26		NEW ISSUE			
B	04.10.06		7.33 WAS 7:20; REMOVE PERIMETER HOLES			
C	05.11.22		Ø1.050 WAS Ø1.000			
D	06.06.26		ADD 4 RIVETS; REMOVE ADHESIVE			



D3163-041 PLATE SHOWN. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19  
(D3163-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)

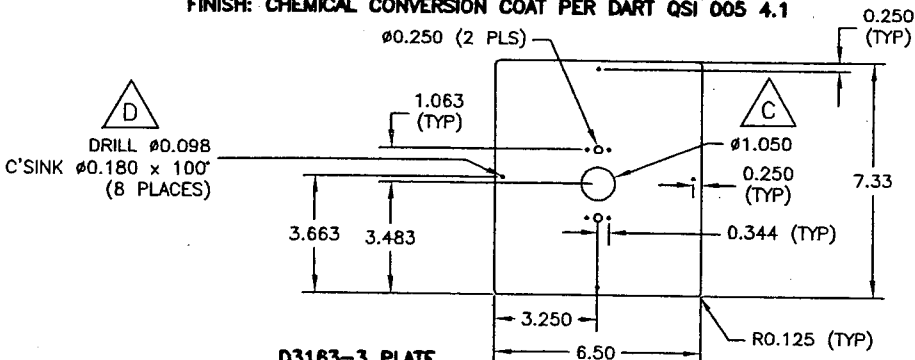


**D3163-1 PLATE**

(D3163-2 PLATE OPPOSITE)

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR  
6061-T6 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M6061T6S.032)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



**D3163-3 PLATE**

MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063) OR  
6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

GENERAL NOTES:

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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